

Work Order ID 60875

Monday, July 26, 2010 12:27:55 PM

Page 1

Item ID: D3536-15

Accept

Revision ID:

Item Name: Gasket

Start Date: 7/26/2010 Start Qty: 12.00

Required Date: 8/3/2010 Req'd Qty: 12.00

Reference:

Approvals: Process Plan: H Date: 10-7-26 Tooling: _____

QC: _____ Date: _____ SPC (Y/N): _____

Cust Item ID:

Customer:

Setup Start

Stop

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3536	Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3536 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Deburr if necessaryB10-7-27

(12)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B10-7-27

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8/10/2010

(12)

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Page 2

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Run Start
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Packaging Packaging	Identify as per dwg & Stock Location: <u>EP</u> Memo	0.00 0.00							<u>6/10/27</u> (12)
140 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>10/07/28</u> (12) <u>10-7-27</u> (12)

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Picklist Print

Monday, July 26, 2010 12:27:59 PM

Page 1

Work Order ID: 60875

Parent Item: D3536-15

Parent Item Name: Gasket



Start Date: 7/26/2010

Required Date: 8/3/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063 		Purchased	No			100	sf	294.2233	0.9848	12.43958			
NEOPRENE SHEET 0.063												1810-7-27	

Location

Loc Qty

Loc Code

MAT

188.9702

114691

188.9702

MAT052

105.2531

114176

105.2531

114691

12

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DART AEROSPACE LTD		Work Order:	60873
Description: Gasket		Part Number:	D3536-15
Inspection Dwg: D3536	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
39.15	+/-0.030	39.15	✓		T 1801	
35.65	+/-0.030	35.65	✓		T	
33.65	+/-0.030	33.65	✓		T	
30.15	+/-0.030	30.15	✓		T	
24.90	+/-0.030	24.96	✓		T	
19.65	+/-0.030	19.65	✓		T	
14.40	+/-0.030	14.40	✓		T	
9.15	+/-0.030	9.15	✓		T	
5.65	+/-0.030	5.65	✓		T	
3.90	+/-0.030	3.90	✓		V 1802	
8.00	+/-0.030	8.00	✓		T	
16.00	+/-0.030	16.00	✓		T	
24.00	+/-0.030	24.00	✓		T	
0.30	+/-0.030	.303	✓		V	
0.30	+/-0.030	.303	✓		V	
1.89	+/-0.030	1.893	✓		V	
Ø0.19	+0.005/-0.001	.191	✓		V	

Measured by: RB	Audited by: S	Prototype Approval:	N/A
Date: 10-7-07	Date: 10/07/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	

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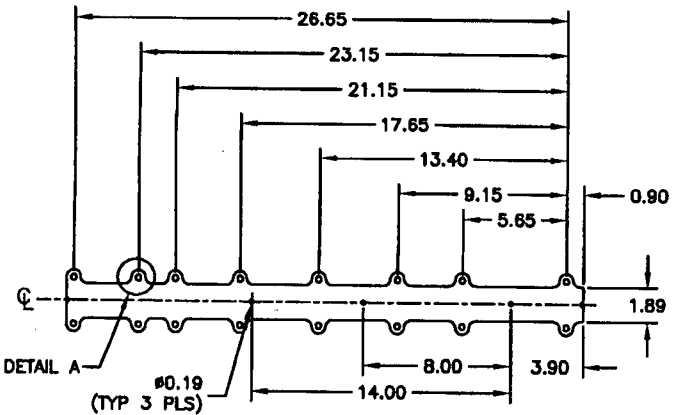
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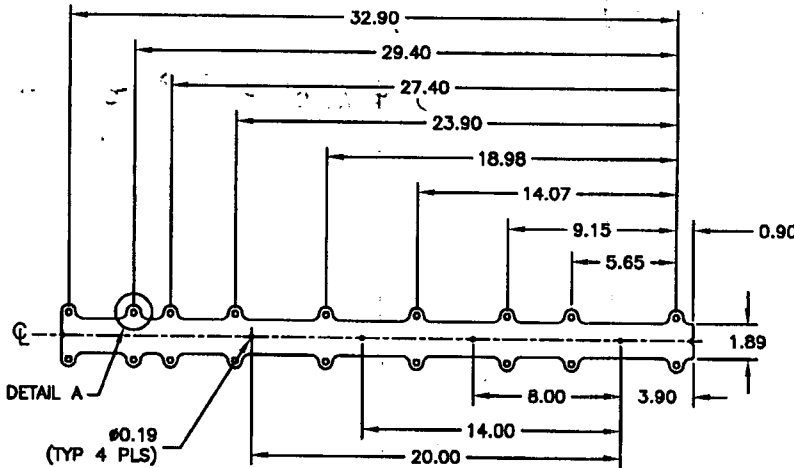
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09.02.12

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 60875
2810-7-24



D3536-11 GASKET



D3536-13 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.083)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

DESIGN	CB	DRAWN BY	CB	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	TITLE	D3536	REV. A
			GASKET	SHEET 1 OF 6
A	06.10.25	NEW ISSUE		SCALE 1:10

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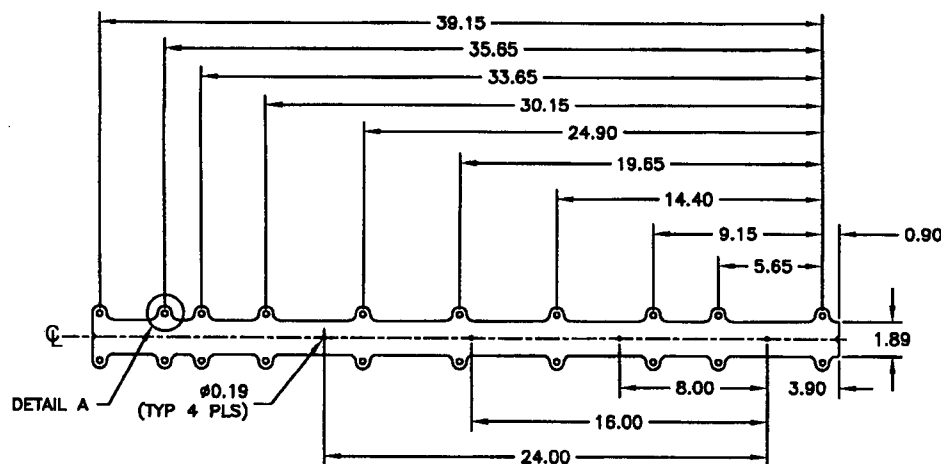
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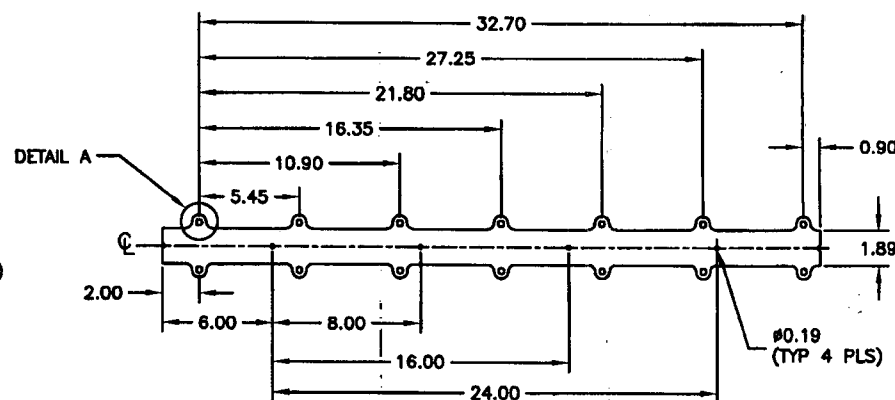
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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 2 OF 6
		SCALE	1:10	

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D3536-15 GASKET

WU 60875



D3536-21 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
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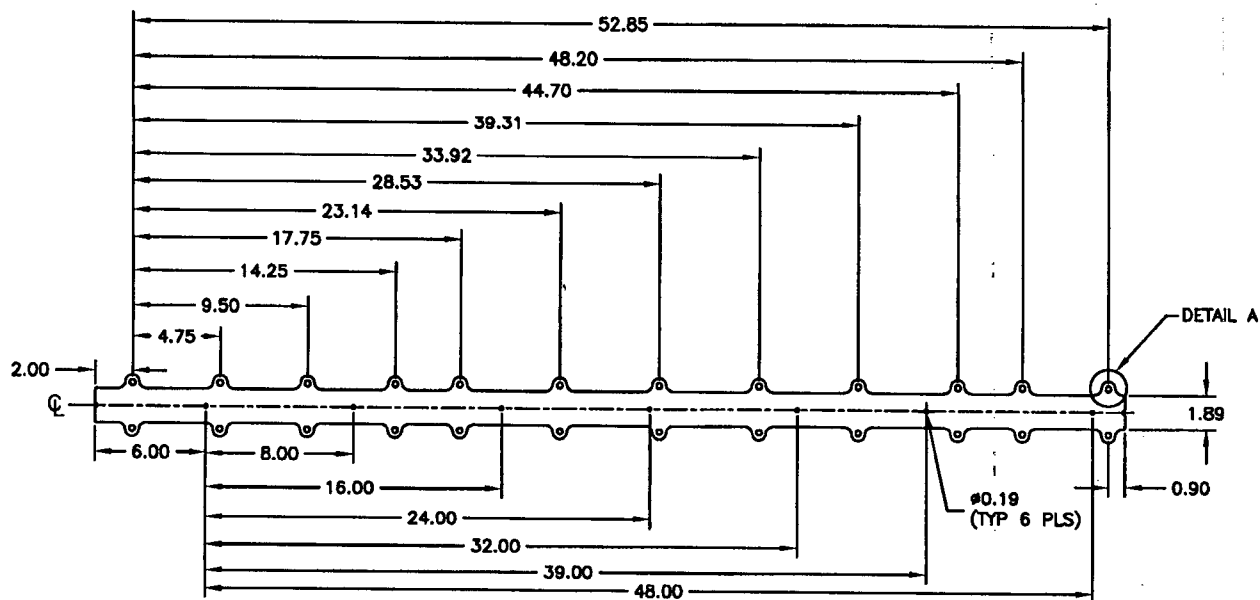
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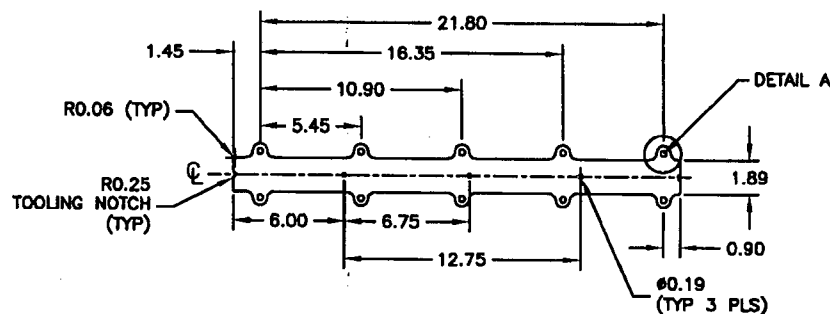
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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	06.10.25	DRAWING NO.	D3536	REV. A
TITLE	GASKET	SHEET	3 OF 6	SCALE
				1:10

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07-02-12



D3536-23 GASKET

w/o 60875



D3536-25 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
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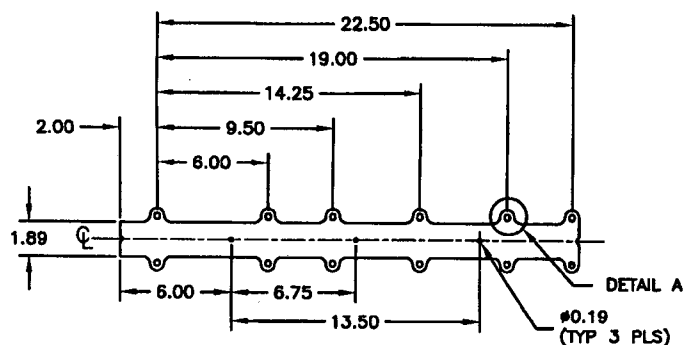
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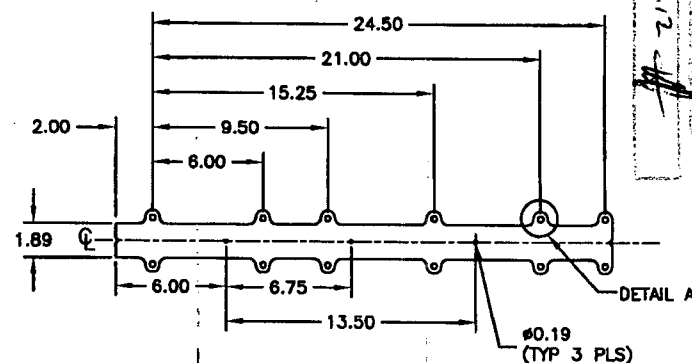
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			GASKET	SHEET 4 OF 6
				SCALE
				1:10

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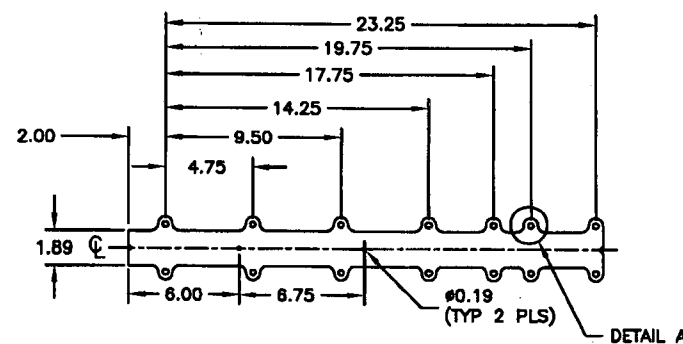


D3536-31 GASKET



D3536-33 GASKET

w/o 60875



D3536-35 GASKET

NOTES

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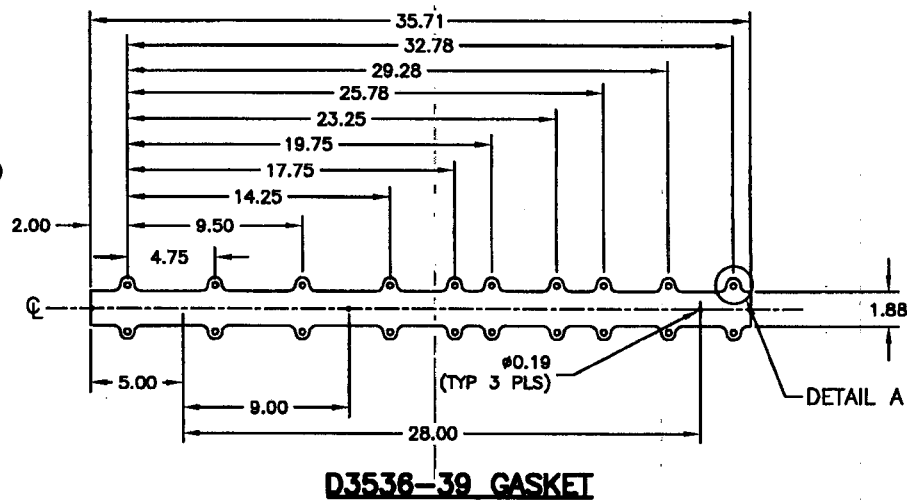
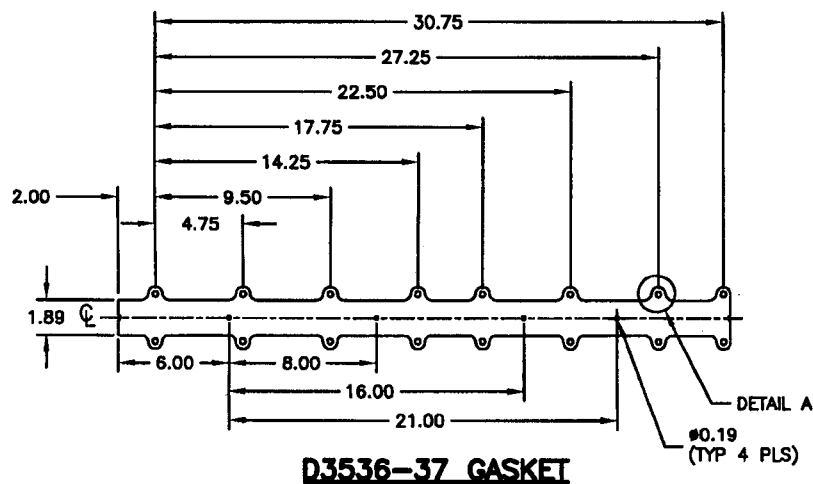
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DATE	06.10.25	TITLE	D3536	REV. A
			GASKET	SHEET 5 OF 6
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07.02.12
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WLO 60875



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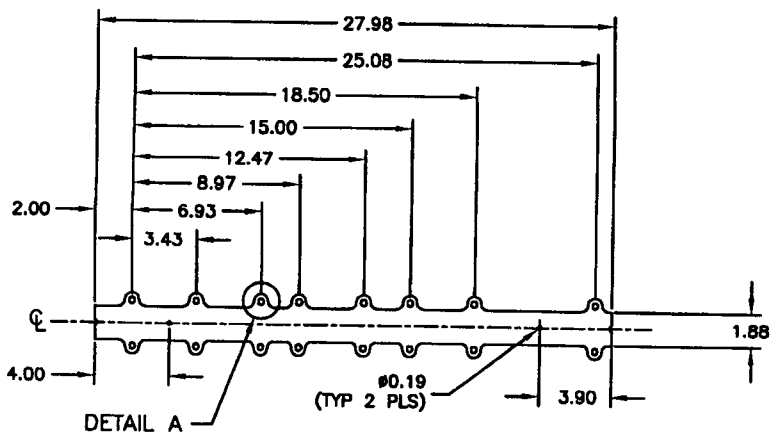
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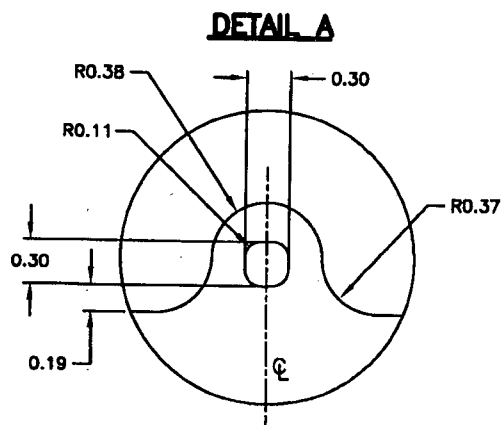
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		SCALE	1:10	

07-01-02-01

also 60875



D3536-41 GASKET



NOTES

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